

Date: Monday, 2/11/2008 2:12:05 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 SADDLE INBOARD, RIGHT SIDE
Job Number	: 37334		
Estimate Number	: 11014		
P.O. Number	:	Part Number	: D26682
This Issue	: 2/11/2008 S.O. No. :	Drawing Number	: D2668 REV. D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	:	Material	:
Written By	:	Due Date	: 3/5/2008 Qty: 4 Um: Each
Checked & Approved By	:		
Comment	: Est: D 02.03.15 Added DEO 9122 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock: 7075-T7351

Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length

Batch No: B34643

DIP 08/04/26

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on 08/04/26 by DIP

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

DIP 08/04/26

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

DIP 08/04/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/04/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:12:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 SADDLE INBOARD, RIGHT SIDE

Job Number: 37334

Part Number: D26682

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8f 08/04/29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

fd 08/04/29

37334
D26682
30/04/2008

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M107530

92 08-04-30

S.163 14.19
#1 323.3 F
#2 30.10 F
#3 --- F
#4 --- F

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-6

08/04/30

4X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 427

AS 08/05/01

4X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01

Job Completion



mf 08-05-01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37334
Description: 206 Saddle, Inboard, Right side	Part Number:	D2668-2
Inspection Dwg: D2668 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.120	0.121	0.121	0.120		
B	0.100	0.140		0.117	0.117	0.118	0.117		
C	1.125	1.145		1.134	1.135	1.136	1.135		
D	0.615	0.685		0.630	0.645	0.645	0.645		
E	0.240	0.260		0.248	0.249	0.249	0.248		
F	1.313	1.343		1.324	1.323	1.323	1.323		
G	0.210	0.220		0.219	0.219	0.219	0.219		
H	0.100	0.180		0.165	0.165	0.165	0.160		
I	2.470	2.510		2.500	2.500	2.500	2.500		
J	1.565	1.585		1.579	1.579	1.580	1.579		
K	0.235	0.240		0.236	0.236	0.236	0.236		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.995	0.996	0.996	0.997		
N	0.510	0.515		0.510	0.510	0.510	0.510		
O	5.990	6.010		6.003	6.003	6.003	6.003		
P	1.245	1.255		1.250	1.250	1.252	1.251		
Q	2.495	2.505		2.502	2.500	2.502	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	1.995	2.005		1.999	2.000	2.000	2.000		
U	1.357	1.367		1.360	1.361	1.361	1.362		
V	0.787	0.807		0.796	0.795	0.7955	0.795		
W	1.040	1.060		1.050	1.052	1.053	1.052		
X	1.674	1.684		1.679	1.679	1.679	1.678		
Y	0.257	0.262		0.259	0.259	0.259	0.259		
Z	0.912	0.932		0.921	0.921	0.9215	0.921		
AA	0.490	0.510		0.499	0.497	0.497	0.497		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>DSR</u>	Audited by: <u>SR</u>
Date: <u>08/04/20</u>	Date: <u>08/04/20</u>

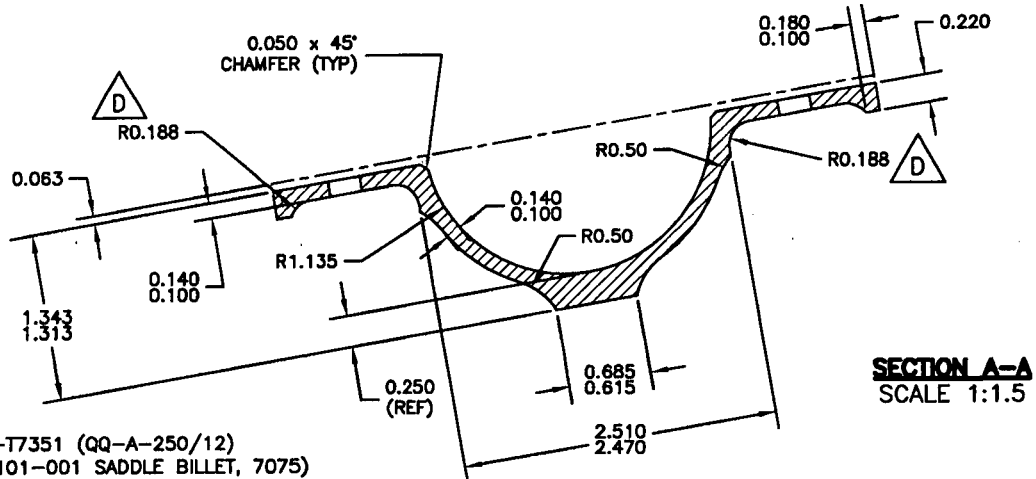
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

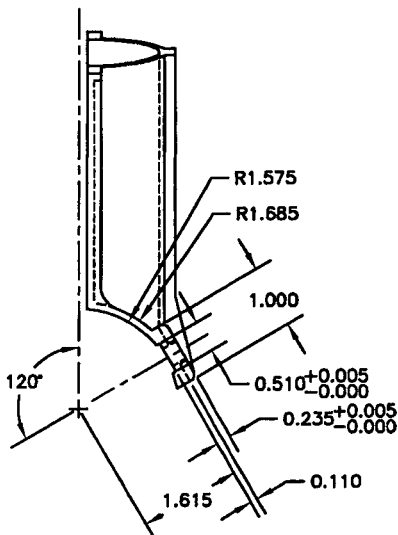
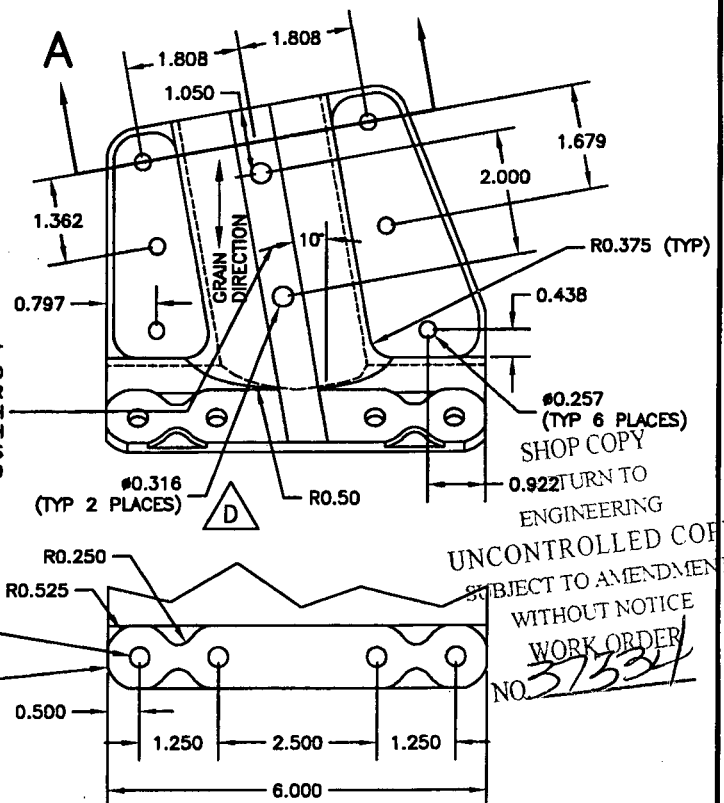
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED A	DRAWING NO. D2668	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE AFT INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

07.02.12

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2668-1 SHOWN (D2668-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2668-1 SADDLE AFT INSIDE HIGH**

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